

Work Order ID 80729-1

February-28-12 10:32:45 AM

\*80729\*

Page 1

Item ID: D4154-041

Accept

\*N900040100\*

Revision ID:

Item Name: Wearplate Assembly

Start Date: 28/02/2012 Start Qty: 6.00

Required Date: 13/03/2012 Req'd Qty: 6.00

Reference:

Cust Item ID:

Customer:

Setup Start

\*NS1\*

Stop

\*NS2\*

Approvals:

Process Plan: MLJ

Date: 12/02/28 Tooling:

QC:

Date: SPC (Y/N):

Date:

Run Start

\*NR1\*

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4154

B

100

0.00

\*100\*

Large Fab

Large Fab

Memo

0.00

1- on D4155-1, fill cut outs with hardcoat welding rod as per dwg D4154

\*\*DT9756\*\*

2059 B Hardcoat Welding Rod

BATCH#: M120392 -> 2059B

2-weld D4155-1 to wearplate by positioning holes together as per dwg D4154

304 S.S. Welding Rod

BATCH #: M120013

3-Transfer drill holes in bar

4- Use DT9684 to check fit after welding

110

QC9- Inspect visual per QS1004- Fusion Welds

0.00

\*110\*

QC

Memo

0.00

Quality Control

MLJ 12-04-03

12.04.04

# Work Order ID 80729

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Page 2

Item ID: D4154-041

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Reference:

Accept

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

\*120\*

QC

Memo

0.00

Quality Control

5/7/12/12

(R)

150

0.00

\*150\*

Small Fab

Memo

0.00

Small Fab

1- After finish, coat entire top (concave) surface as per note 11 on sheet 2 of 3  
dwg D4154.

B120858

AB 12-4-4

160

QC5- Inspect part completeness to step on W/O

0.00

\*160\*

QC

Memo

0.00

Quality Control

5/7/12/12

(R)

**Work Order ID 80729**

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**\*80729\***

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Item ID: D4154-041

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Start Date: 28/02/2012 Start Qty: 6.00

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Reference:

Accept

**\*N900040100\***Setup Start **\*NS1\***Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

170

Identify as per dwg & Stock Location: EP-1

0.00

**\*170\***

Packaging

Memo

0.00

Packaging

v2 f All n/a 1/8/12

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

12/4/12

mk

12-04-04

# Picklist Print

February-28-12 10:32:49 AM

Page 1

Work Order ID: 80729

\*80729\*

Parent Item: D4154-041

\*D4154-041\*

Parent Item Name: Wearplate Assembly

Start Date: 28/02/2012

Required Date: 13/03/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.09.21 new issue DD ver:EC  
10.11.04 added DT9684 DD ver:EC  
per dwg revB DD ver:EC

IPP Rev:B  
IPP Rev:C 11.04.14 as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4154-1		Manufactured	No			100	Each	5.0000	1	6		12-04-03	
*D4154-1*													
Plate													

\*\*

Location	Loc Qty	Loc Code
WA	5	
66312	1	
77014	4	
	100	
	Each	
	2.0000	
	1	
	6	

D4155-1

\*D4155-1\*

Bar

\*\*

Location	Loc Qty	Loc Code
WA	2	
77013	2	

80729 x 2

B/me 12-04-03

ITEM	QTY	P/N	DESCRIPTION
	X	D4154-041	WEARPLATE ASSEMBLY
1	1	D4154-1	PLATE
2	1	D4155-1	BAR
3	A/R	2059B	HARDCOAT
4	A/R	4714	PLUS ONE ROCKGUARD (SEE NOTE 11, SHT 2)



D4154-041 WEARPLATE ASSEMBLY

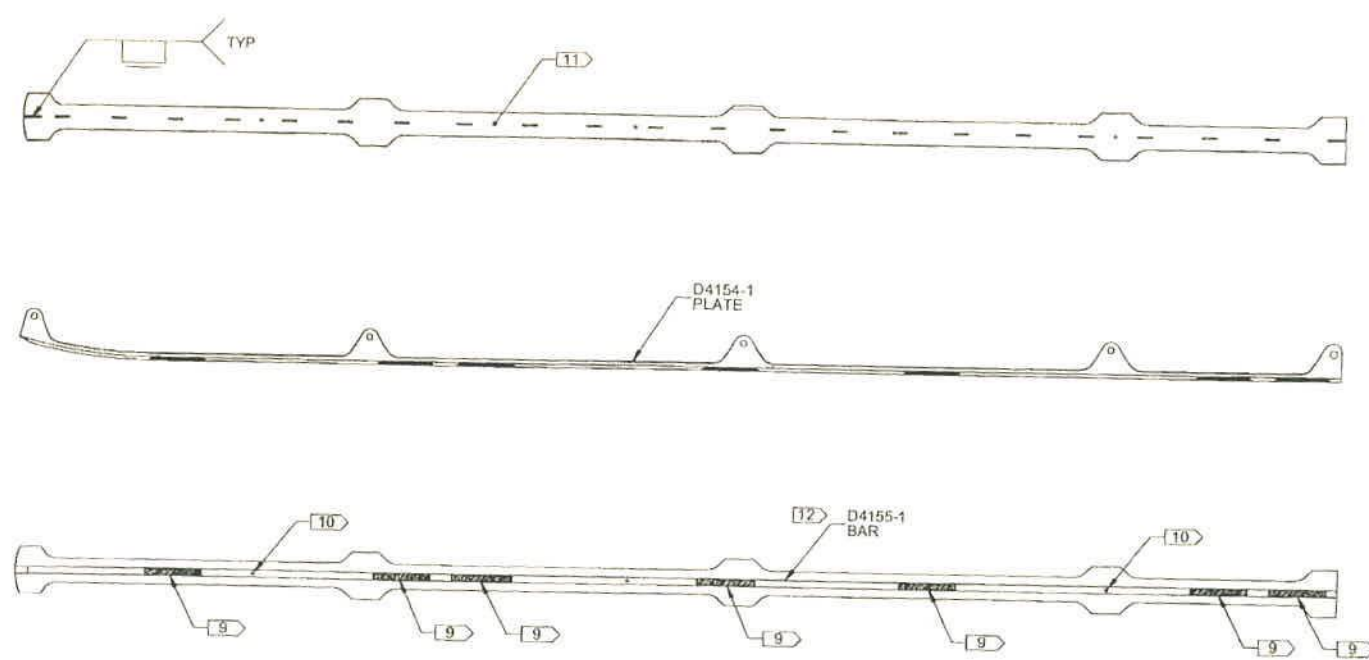
80729 MCT  
12/02/28

RELEASED  
2011-04-12  
JMD

REV.	DESCRIPTION	BY	DATE
B	ITEM 4 WAS PR1422 (D3-1) REMOVED FINISH TO NOTE 2 (AS-2) REMOVED SECTION A-A (NO LONGER REQUIRED); REVISED D4154-1F	MB	11.04.05
A	NEW ISSUE	SC	10.07.22
DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	SC	DRAWING NO.	REV. B
CHECKED	SC	D4154	SHEET 1 OF 3
MFG. APPR.	SC	TITLE	SCALE
APPROVED	SC	WEARPLATE ASSEMBLY	NTS
DE APPR.	SC	DATE 11.04.05	
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**D4154-041 WEARPLATE ASSEMBLY**

**RELEASED**  
2011-04-13

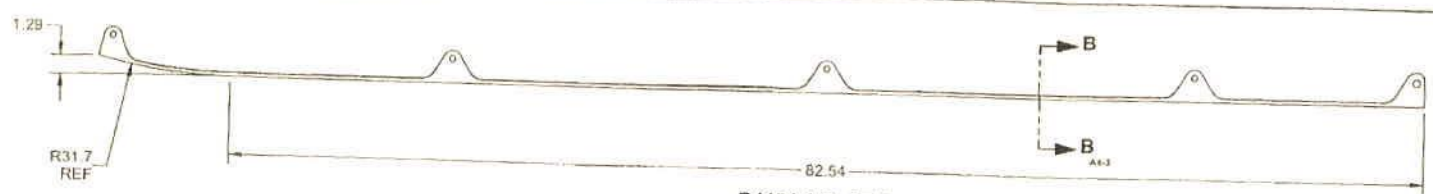
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D4154-041" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 6.88 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D4154-1 BAR ON ALL 3 SURFACES AT 7 PLACES
- 10) TRANSFER DRILL  $\varnothing 0.188$  HOLES FROM D4154-1 PLATE TO D4155-1 BAR
- 11) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 12) FORM TO MATCH PROFILE OF D4154-1 AT TIME OF WELDING

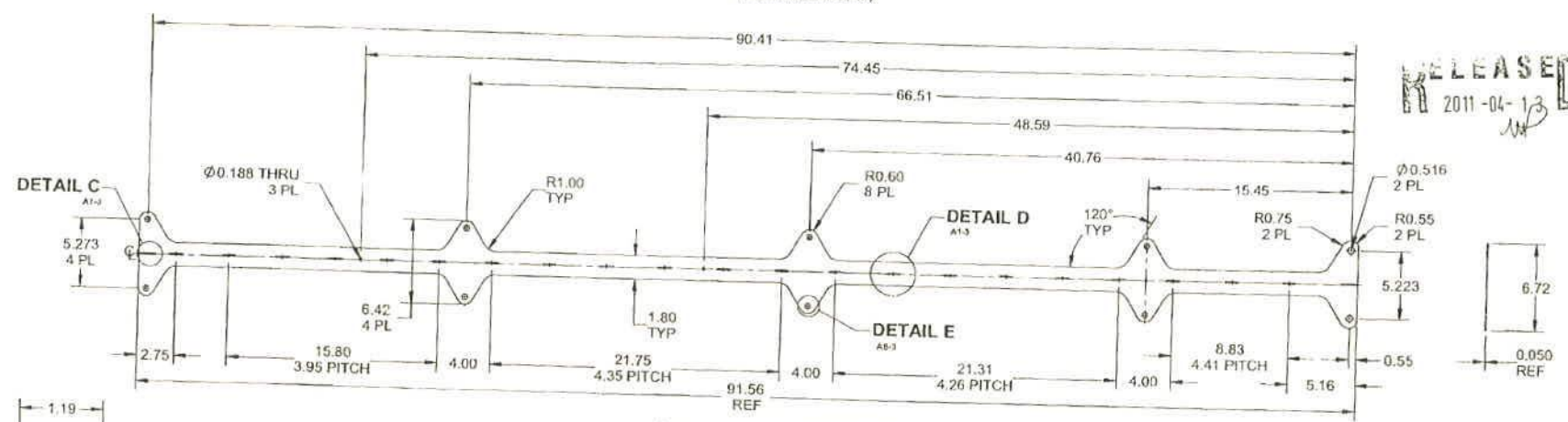
DESIGN	SC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	5	PORT HADLOCK, WA	
CHECKED	CP	DRAWING NO.	REV. B
MFG. APPR.	MP	D4154	SHEET 2 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	WEARPLATE ASSEMBLY	NTS
DATE	11.04.05	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.</small> <small>THE DOCUMENT IS PREPARED AND CONTROLLED BY DART AEROSPACE USA, INC. IT IS THE PROPERTY OF DART AEROSPACE USA, INC. AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.</small>	

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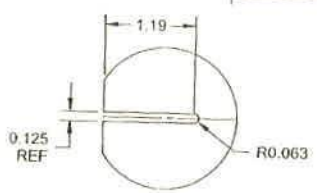
RELEASED  
2011-04-13



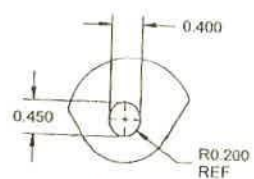
**D4154-1 PLATE**  
(MAKE FROM D4154-1F)



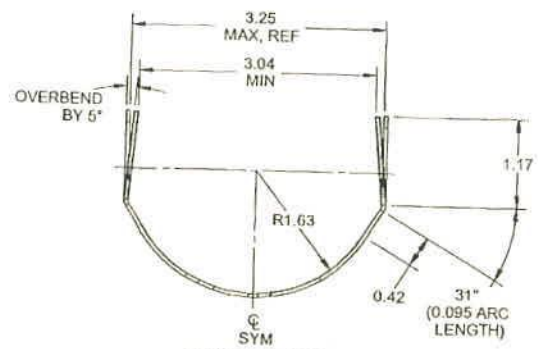
**D4154-1F FLAT PATTERN**



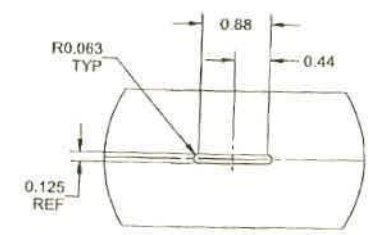
**DETAIL C**  
END SLOT DETAIL, 2 PL C7.3



**DETAIL E**  
SLOT DETAIL TYP C4.3



**SECTION B-B** C3.3



**DETAIL D**  
SLOT DETAIL TYP C4.3

- NOTES:**
- 1) MATERIAL : AISI 304/316 STAINLESS STEEL PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
  - 2) FINISH : NONE
  - 3) TOLERANCES : PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS : INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES : 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION : NONE
  - 7) WEIGHT : 2.95 lbs

DESIGN	SC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG APPR.		<b>D4154</b>	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>WEARPLATE ASSEMBLY</b>	NTS
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